



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2894-1**Job Sheet 191141****Part No:** D2894-1**Job Qty:** 12 pcs**Part Name:** 2.75 Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/21/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Jesse White**Type:** Stock**Description:**

Note: DWG REV E IPP: B 02.11.26 Added mask hole KJ IPP Rev:C ECN 993 07-11-07 DD verified by:EC IPP D 08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	3/22/19	0.79	29.56		HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	12 pcs	3/22/19	0.00	0.00		QC 8 - 12		<i>W. 2019/04/10</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 47		
130	Packaging 3-1 - Stock - B4B	12 pcs	3/22/19	0.00	0.00		Packaging 3 - 1 - B4B		<i>2019/04/20</i>
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

Plex 2/21/19 3:55 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐
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Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐														
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____													
Description Work Order Devi DART Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON K6A 1K7 CANADA TEL: 1 513 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S171563 Part: D2894-1 Job No: 191141 Serial No/Batch: S171563 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 04/10/19																	

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	LG051 AS 19-4-20
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
140 QC 21 - SA	12 pcs	3/22/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	21
					QC 21 - SA - 53	21

APR 22 2019

Part Op **100** - (HAAS CNC Vertical Machine) Machine as per Folio FA253 Tumble & Deburr
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____) LOCATION : LG051
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK079	D2894-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	517/563

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK079	6	2	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
2	2.750 Support	3.062Inches + 0.020 - 0.000	3.082 3.062		
3	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
4	2.750 Support	1.766Inches + 0.020 - 0.000	1.786 1.766		
5	2.750 Support	0.020Inches + 0.020 - 0.000	0.040 0.020		
6	2.750 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
7	2.750 Support	0.170Inches + 0.020 - 0.000	0.190 0.170		
8	2.750 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
9	2.750 Support	1.970Inches + 0.060 - 0.000	2.030 1.970		
10	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.750 Support	1.880Inches + 0.020 - 0.000	1.900 1.880		
12	2.750 Support	0.500Inches + 0.005 - 0.000	0.505 0.500		
13	2.750 Support	0.188Inches + 0.006 - 0.000	0.194 0.188		

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DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		0.464	0.462	0.464	0.464	0.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AD	1.766	1.786		1.783	1.783	1.782	1.782	1.782
AE	0.020	0.040		0.030	0.030	0.030	0.030	0.030
AF	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AG	0.170	0.190		0.180	0.180	0.180	0.180	0.180
AH	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AI	1.970	2.030		2.0035	2.0035	2.002	2.002	2.001
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.890	1.890	1.890	1.890	1.890
AL	0.500	0.505		0.501	0.501	0.501	0.501	0.501
AM	0.188	0.194		0.190	0.190	0.190	0.190	0.190
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by:	<i>M.M.</i>	Date:	<i>2019/04/10</i>
Audited by:	<i>M.M.</i>	Date:	<i>19/04/20</i>
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2894-1
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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 <i>1</i>	7 <i>2</i>	8 <i>3</i>	9 <i>4</i>	10 <i>5</i>
HAAS Section								
AA	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AD	1.766	1.786		1.782	1.782	1.782	1.782	1.782
AE	0.020	0.040		0.030	0.030	0.030	0.030	0.030
AF	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AG	0.170	0.190		0.180	0.180	0.180	0.180	0.180
AH	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AI	1.970	2.030		2.002	2.002	2.001	2.000	2.000
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	1.880	1.900		1.890	1.890	1.890	1.890	1.890
AL	0.500	0.505		0.501	0.501	0.501	0.501	0.501
AM	0.188	0.194		0.190	0.190	0.190	0.190	0.190
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by: <i>KJ</i>	Date: <i>19-04-11</i>
Audited by: <i>mmL</i>	Date: <i>19/04/20</i>
Preliminary Approval:	Date:

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AK	1.880	1.900		1.890	1.890			
AL	0.500	0.505		0.501	0.501			
AM	0.188	0.194		0.190	0.190			
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by: <i>[Signature]</i> ^{DAS} 1	Date: 19-04-12
Audited by: <i>[Signature]</i> ⁹⁻⁸⁹	Date: 17/04/20
Preliminary Approval:	Date:

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A	02.12.12	New Issue	KJ/RF	
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